

# Work Order ID 76739

**\*76739\***

Page 1

Monday, November 21, 2011 9:53:18 AM

Item ID: D3806-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Bar  
 Start Date: 11/21/2011 Start Qty: 50.00 **\*50\*** Cust Item ID:  
 Required Date: 12/20/2011 Req'd Qty: 50.00 **\*50\*** Customer:

## Reference:

Approvals: Process Plan: *[Signature]* Date: 11-21 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3806	B								

100 0.00  
**\*100\***  
 Cold Saw Memo 0.00 *cut 11/11/26* 50 *g*  
 Hyd Mech Cut blanks at 43.600"

110 0.00  
**\*110\***  
 HAAS 1 Memo 0.00 *cut 11/12/01* 50 *g*  
 HAAS CNC vertical machine #1 1-Mill as per folio FB070 & dwg  
 FOLIO REV: 4A  
 DWG REV: B  
 2-Deburr as required

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00				50	0		
Quality Control									
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									
133	Weld per dwg A/R Hardcoat S.S. Batch: _____	0.00							
<b>*133*</b>									
Large Fab	Memo	0.00							
Large Fab	1- On D3806-1, fill cut outs with hardcoat welding rod as per dwg D3805 2059 B Hardcoat Welding Rod BATCH#:								

*will be done on assembly  
w/o. h*

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
136 <b>*136*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00	Done on assembly w/o						
137 <b>*137*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00							
140 <b>*140*</b> Packaging Packaging	Identify as per dwg & Stock Location: <i>w/a</i>  Memo <i>030</i>	0.00  0.00							

*11-22-2011* *X50*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Monday, November 21, 2011 9:53:18 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**\*50\***

**\*50\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop **\*NR2\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

**Insp.  
Stamp**

0.00


**\*150\***

QC

## Memo

0.00

## Quality Control

Number Stamp  
11/12/5 

11-12-02  
(30)

W/O:		WORK ORDER CHANGES					
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# Picklist Print

Monday, November 21, 2011 9:53:27 AM

Page 1

Work Order ID: 76739

\*76739\*

Parent Item: D3806-1

\*D3806-1\*

Parent Item Name: Bar

Start Date: 11/21/2011

Required Date: 12/20/2011

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:ec  
IPP Rev:B 08-09-23 redesign DD verified by:EC  
IPP Rev:C 08-09-30 redesign DD verified by:EC  
D 11.06.03 re-design EC verified by:DD  
rev.b as per dwg DD verified by:EC  
IPP rev  
IPP Rev:E 11.10.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250x0.500		Purchased		No		100	f	1,035.416	3.66	192.6316			

\*M304B0 250x0 500\*

\*\*

304 BAR .250 x .500

Location	Loc Qty	Loc Code
MAT006	997.522	
117842	8.3	
119050	21.67	
119159	967.552	
MAT050	37.8947	
117176	37.8947	

200'

OK 11/11/26

W/O:		WORK ORDER CHANGES					
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## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	
B	11.10.13	Dimensions updated per Dwg Rev B	KJ	

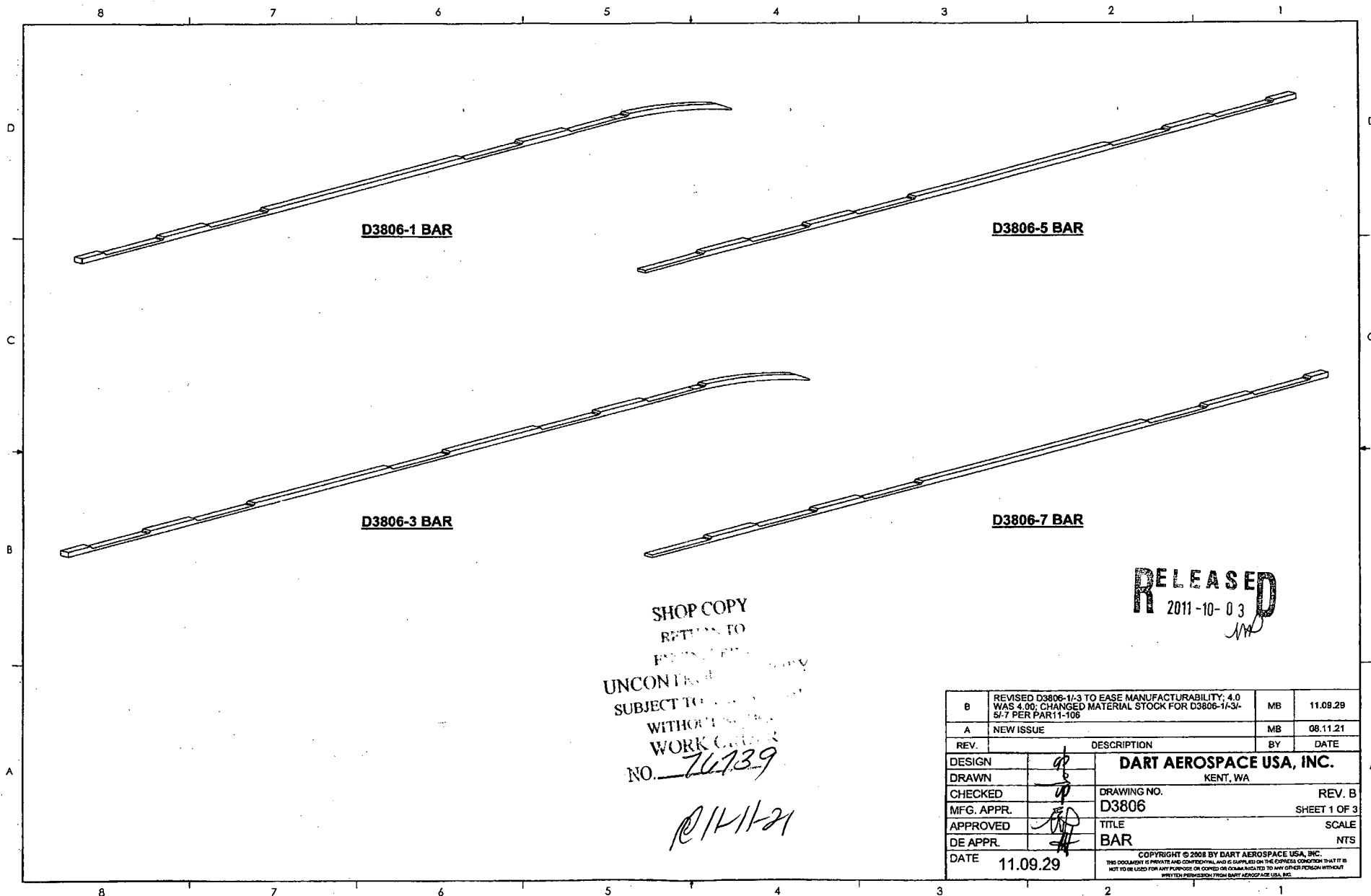
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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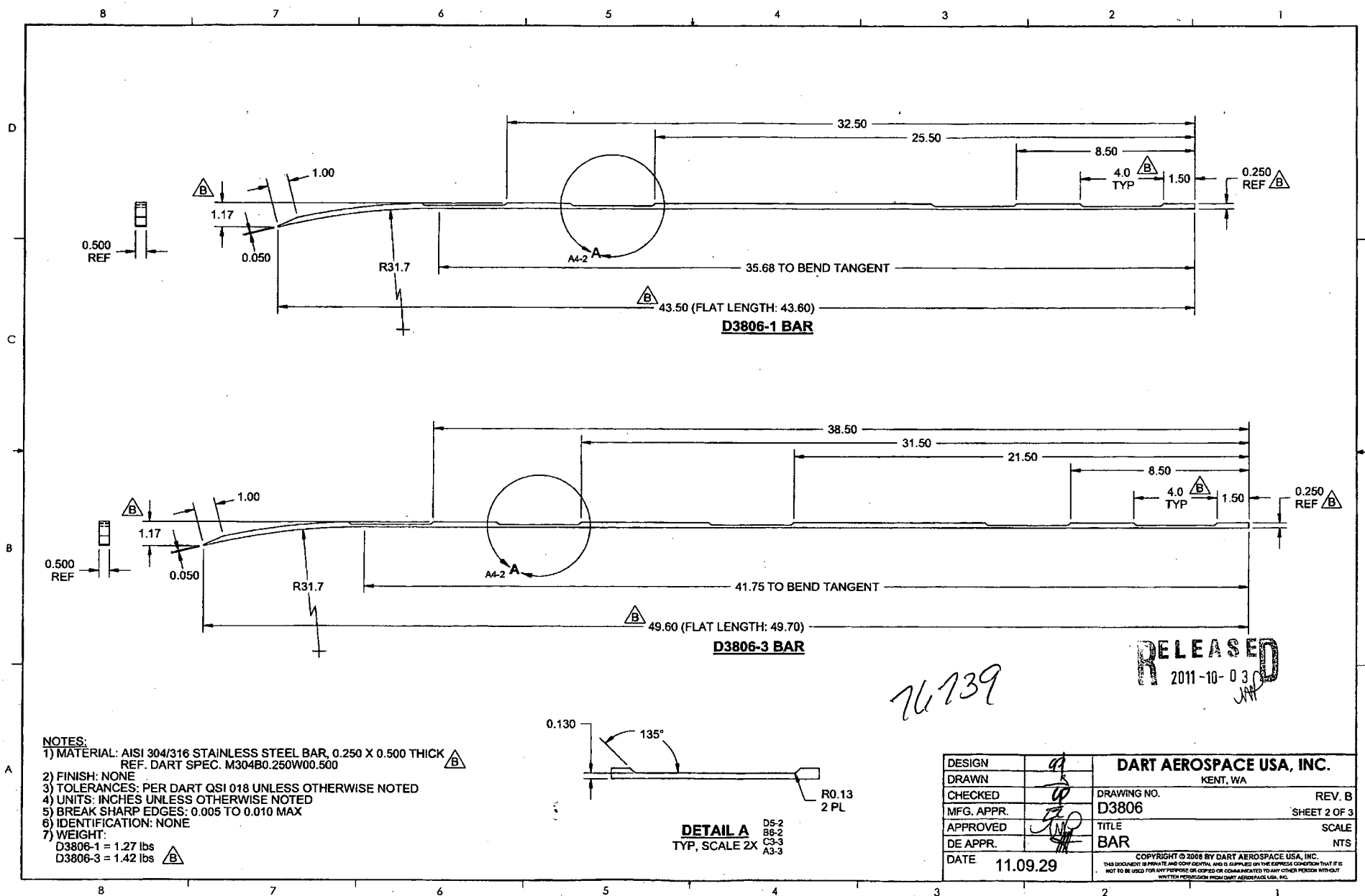
W/O:		WORK ORDER CHANGES					
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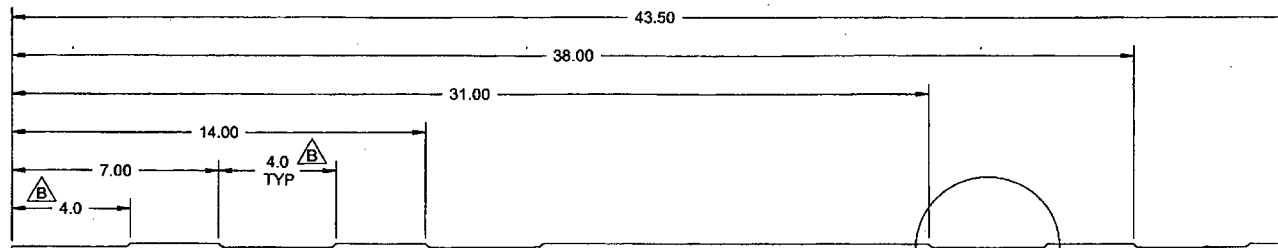
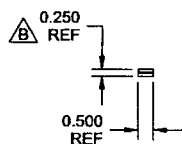
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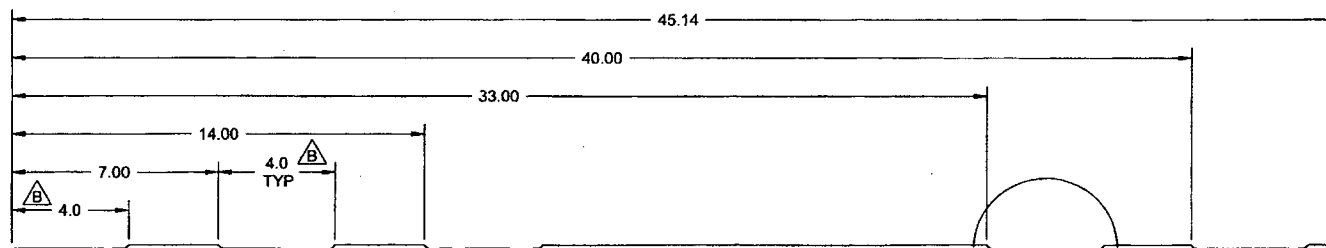
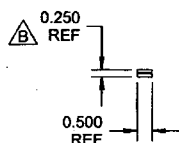
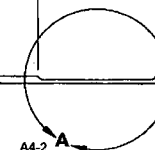
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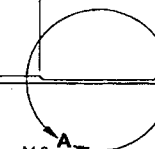
8 7 6 5 4 3 2 1



**D3806-5 BAR**



**D3806-7 BAR**



**RELEASED**  
2011-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR, 0.250 X 0.500 THICK  
REF. DART SPEC. M304B0.250W00.500
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT:  
D3806-5 = 1.22 lbs  
D3806-7 = 1.28 lbs

76139

DESIGN		<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3806</b>	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 3 OF 3	
APPROVED	<i>[Signature]</i>	TITLE <b>BAR</b>	SCALE NTS
DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.	
DATE	11.09.29	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

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